

Date: Monday, 12/01/2009 2:36:52 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 44654		
Estimate Number	: 12634		
P.O. Number	:	Part Number	: D35491
This Issue	: 12/01/2009 S.O. No. :	Drawing Number	: D3549 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 31125	Material	:
Written By	:	Due Date	: 02/02/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JLD 09.01.13</u>		
Comment	: Est Rev:A New Issue 06-11-13 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.2205 sf(s)/Unit Total : 1.3230 sf(s)
 6061-t6 aluminum sheet .080 Sheet
 Batch: 111006

ml 09 04 02

(6)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3549
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

ml 09 04 02

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 04 02

(6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/04/03

(6)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D3549

SB 09/04/03

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44654

Part Number: D35491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/16 (x6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LMH/HA

09/04/17

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110939

START TIME:

1:00

OVEN TEMPERATURE:

320°

FINISH TIME:

1:30

BR 09-04-20 (6)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD. #

09-04-20

04-20

(x6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

114

9/4/20

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

Job Completion



MF 09-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

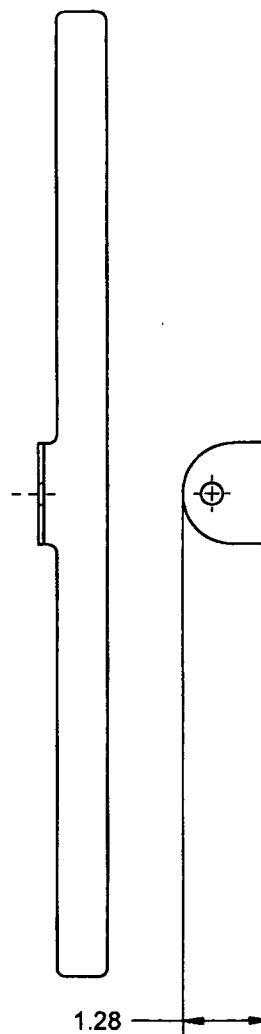
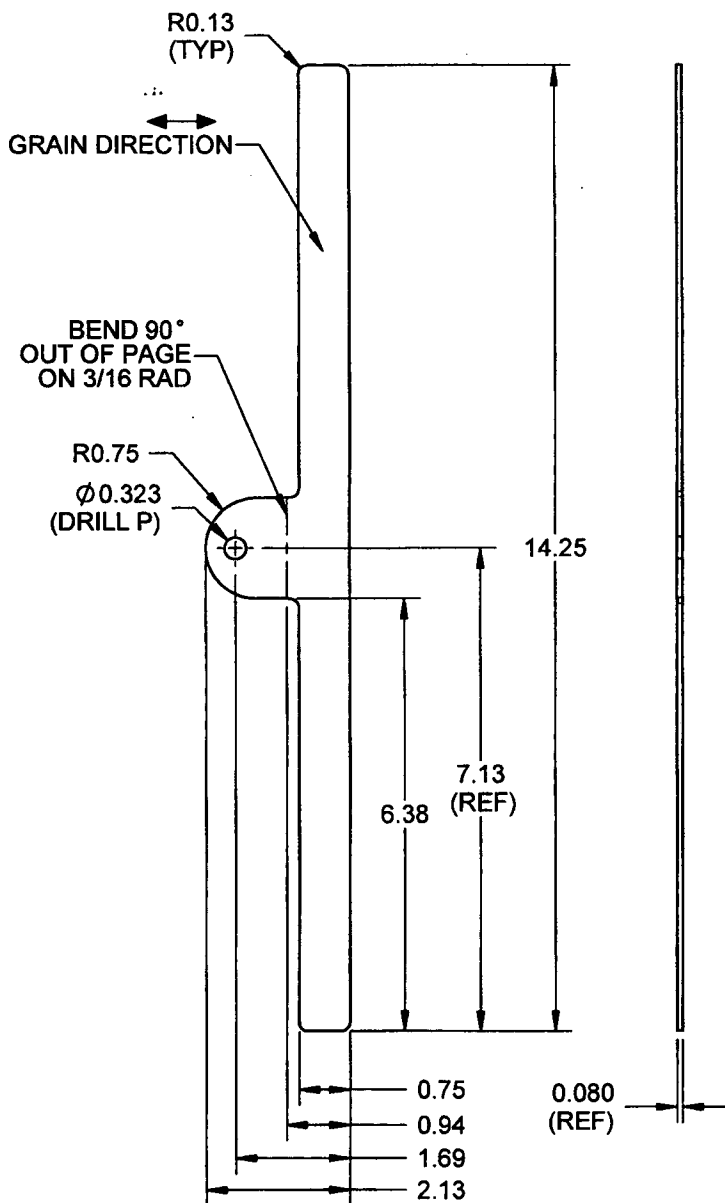
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3549	REV. A SHEET 1 OF 1
DATE 06.10.10	TITLE BRACKET		SCALE 1:1
REV A	DATE 06.10.10	DESCRIPTION NEW ISSUE	

**D3549-1 BRACKET****D3549-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.080 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1. POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3549-1 USING FINE POINT PERMANENT MARKER

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RELEASED
06.10.2010

NO. 44654